

Work Order ID 55709

January 28, 2010 10:49:30 AM



Page 1

Item ID: D3943-3

Revision ID:

Item Name: Handle Extension

Start Date: 1/29/2010 Start Qty: 6.00

Required Date: 2/15/2010 Req'd Qty: 6.00

Reference:

Accept



Setup Start

Stop

Cust Item ID:

Customer:



Approvals: Process Plan: UMF

Date: 10-1-28 Tooling:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3943

B

100



Waterjet

FLOW CNC Waterjet

1010 .SX 3,0

Memo

1-Cut as per Dwg D3943

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

0.00

0.00

0.00

0.00

MAT NOT PULLED

AB 10-2-2

=> Deburr m-k w/oil/o8 (6x) (6)

AB 10-2-2

110



QC

Quality Control

Memo

QC2- Inspect parts off machine FAI/FAIB

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Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

⇒ 8/10/04

(x6)

130



Mill Conv

Conventional Milling Machine

Manufacture as per dwg

Memo

1-MILL DIMPLE USING 3/8" BALL + .37 dia.

0.00

0.00

8/10/04

2- elems used for plk

clean-up m.f. 10/01/08 (Gx)

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

⇒ 8/10/09

(x6)

140



QC

Quality Control

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Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



SprayPaint

Spray Painting

Memo

1- SPRAY PAINT YELLOW AS PER DWG
A/R BATCH

0.00

0.00

Start tie 2:15pm

Quantities 3209

Finish time 2:41pm

MA 113 544

10/02/09 X6 / 0

Reg 057025

0.00

0.00

10-02-09



160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

Identify as per dwg & Stock Location: w/o

55706

Memo

170



Packaging

Packaging

12 10-3-15



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Reference:



Cust Item ID:
Customer:



Setup Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/
Work Center ID

180



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Memo

0.00

10/03/16

[Signature]

pl 10-3-14
[Signature]

Picklist Print

January 28, 2010 10:49:29 AM

Work Order ID: 55709

Parent Item: D3943-3

Parent Item Name: Handle Extension

Comments:



Page 1

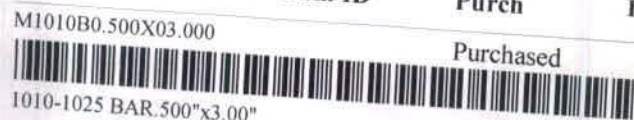
Start Date: 1/29/2010

Required Date: 2/15/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M1010B0.500X03.000		Purchased	No			100	f	1.9600	7.5600			



1010-1025 BAR.500"x3.00"

Warehouse

Location

Main Warehouse

MAT

108336

Loc Qty

1.96

1.96

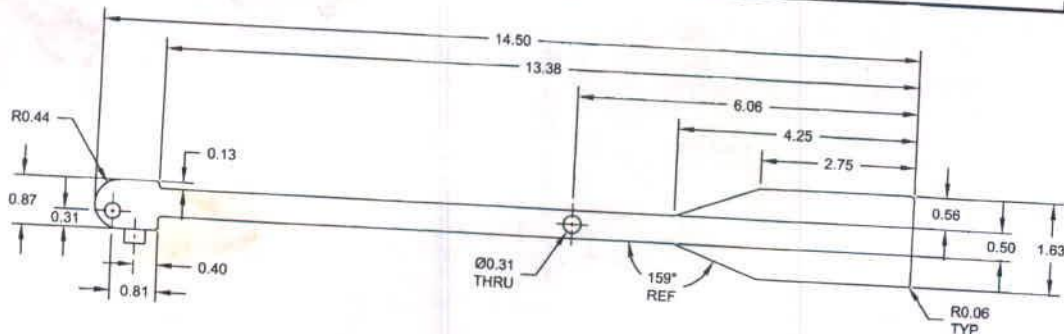
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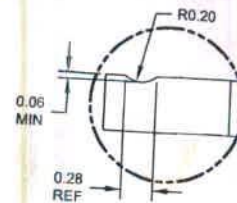
108336

13 10-2-2

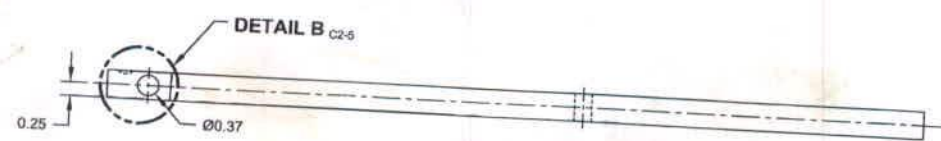
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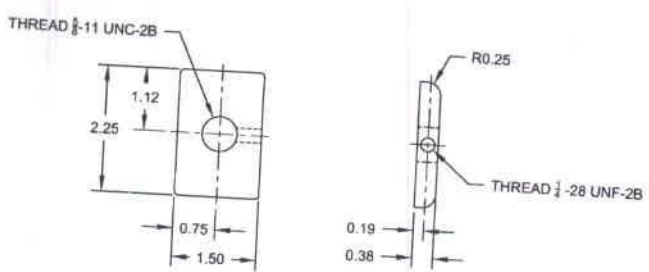
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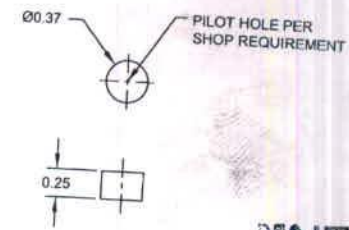
DETAIL B-B
(Dimple Detail)
(Scale 2X)



D3943-3 HANDLE EXTENSION



D3943-5 PLATE



D3943-7 STUD
(Scale 2X)

- NOTES -11/-13:**
- 1) MATERIAL -3 & -5: MILD STEEL, SHEET
AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-S
 - OR: MILD STEEL, BAR
AISI 1010-1025 OR ASTM A36/A366/A569/A570
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-B
 - 7: MILD STEEL, ROUND BAR
AISI 1018-1025
PER MIL-S-7097
REF DART SPEC M1018-R

YELLOW POWDER COAT
11/20/10

- 2) FINISH -3: SPRAY PAINT YELLOW WITH BERTRAND 60103IB PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A

DEO ATTACHED
RELEASED
2009-10-19

DESIGN	DSTOW / AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS	DRAWING NO.	REV. B
CHECKED		D3943	SHEET 5 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		GROSS WEIGHT TOW CRANK ASSY	NTS
DE APPR.		COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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